

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011814**Date Inspected:** 02-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6BW-6CW)

**SMAW Process:**

Welding of weld joint -004 and 005 located on PCMK OBW6C, transverse splice weld joining side panel of 6BW and 6CW at crossbeam side. Welder is identified as 067949. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-WR10382 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (7AW-7BW)

**FCAW Process:**

Welding of weld joint -002 located on PCMK OBW7, transverse splice weld joining Deck panel of 7AW and 7BW. Welder is identified as 067275. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2) T-2.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

OBG # TRIAL ASSEMBLY YARD (6CW)

SMAW Process:

Welding of weld joint –002 located on PCMK CA029, Corner assembly weld joining Edge and Deck Panel of 6CW at counterweight side. Welder is identified as 067764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (6CW)

SMAW Process:

Welding of weld joint –006 located on PCMK CA031, Corner assembly weld joining Edge and Deck Panel of 6CW at crossbeam side. Welder is identified as 067764. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-Tc-U4b-FCM-1.

OBG # TRIAL ASSEMBLY YARD (7AW-7BW)

SMAW Process:

Welding of weld joint –005 located on PCMK OBW7, transverse splice weld joining Edge panel of 7AW and 7BW. Welder is identified as 050433. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW Process:

Welding of weld joint –003 located on PCMK OBW7B, transverse splice weld joining bottom panel of 7AW and 7BW. Welder is identified as 050316. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T.

FCAW Process:

Welding of weld joint –002 located on PCMK OBW7B, transverse splice weld joining Side panel of 7AW and 7BW. Welder is identified as 066746. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No Relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

remedial efforts please contact , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

---

<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
---------------------	-------------	-------------